

Work Order ID 163413

Tuesday, June 27, 2017 11:39:03 AM

163413

Page 1

Item ID: D5149-043W

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Step Base Assembly Weldment

Start Date: 7/7/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JUL 12 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5149	D

110

Weld per dwg A/R Aluminum rod Batch: 136/58 0.00***110***

Large Fab

Memo

2.52

Large Fab

USE DT10135 WELDING FIXTURE TO WELD D5149-043

4 AUG 03 2017

DAS
24
9-89

120

QC9- Inspect visual per QS1004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

DAS
43
9-89

4 AUG 09 2017

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.08

Quality Control

DAS
38
9-89

4 AUG 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.59							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.04							
Quality Control									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.14							
Powder Coating									
	START TIME: 7:30								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 8:00								

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Page 4

Item ID: D5149-043W

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Step Base Assembly Weldment

Start Date: 7/7/2017 Start Qty: 4.00

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Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
200					DAS				
Packaging	Memo	0.04			30	4			SEP 05 2017
Packaging					9-89				
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.40							17/9/16 DJ
Quality Control									

DAS
21
9-89

SEP 05 2017

DQA: _____ Date: _____



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Picklist Print

Tuesday, June 27, 2017 11:39:00 AM

Page 1

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163413

Parent Item: D5149-043W

D5149-043W

Parent Item Name: Aft Step Base Assembly Weldment

Start Date: 7/7/2017

Required Date: 7/14/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.12.15 NEW ISSUE DD VERF;JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D5149-5 Step Cap		Manufactured	No			110	Each	14.0000	1	4			
**													
D.M.L 2017-8-2													
163706 = 4													
Location													
WA001													
145680													
161881													
110													
Each													
12.0000													
1													
4													
D5149-7 Aft Step Base													
**													
D.M.L 2017-8-2													
158740 = 2													
161345 = 2													
Location													
WA002													
158740													
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1													
4													
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**													
AUG 08 2017													
Location													
WA001													
158886													
162827													
110													
Each													
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7													
10													
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DAS
24
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		OTHER : ☐							

D

2

•

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lbs
- 8) WELDING PER DART QSI 004
- 9) APPLY BLACK ANTI-SKID PAINT TO STEP TUBE, ALL AROUND PER DART QSI 005 4.4
- 10) ALIGN D5149-9 AFT STEP WITH EDGE OF ALIGNMENT HOLES IN D5149-7 AFT STEP BASE PRIOR TO WELDING

RELEASED
2015-11-04

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